

Work Order ID 118450

Tuesday, September 09, 2014 11:23:56 AM

118450

Page 1

Item ID: D206-642-512 REPAIR

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube LH,High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float Compatible

Start Date: 9/9/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/10/2014 Req'd Qty: 1.00

1

Customer: CEDWA01

Reference: RMA RA111862

Approvals: Process Plan: mf Date: 4-9-9

Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN-D206-642	Q

100

0.00

100

QC

Memo

0.00

Quality Control

INSPECT RA 111862 D206-642-511 X 1 B112860

REWORK PER RS 1021

- 541 (112943)

110

0.00

110

HandFinish

Memo

0.00

Hand Finishing

SEE RS1021

1x d. ju 10/09/14

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

1 DAS 38 14-9-15
9-89

Work Order ID 118450***118450***

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Tuesday, September 09, 2014 11:23:56 AM

Item ID: D206-642-512 REPAIR**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Stop *NS2*****Item Name:** Skidtube LH,High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float Compatible**Start Date:** 9/9/2014 **Start Qty:** 1.00 ***1*****Cust Item ID:****Required Date:** 9/10/2014 **Req'd Qty:** 1.00 ***1*****Customer:** CEDWA01**Reference:** RMA RA111862**Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start *NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo	0.00							
Packaging	ID AND STOCK UNDER NEW BATCH NUMBER								
	NO PAPERWORK NEEDED								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

ME 14-9-14

Picklist Print

Page 1

Tuesday, September 09, 2014 11:23:52 AM

Work Order ID: 118450

118450

Parent Item: D206-642-512 REPAIR

D206-642-512 REPAIR

Parent Item Name: Skidtube LH, High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float Compatible

Start Date: 9/9/2014

Required Date: 9/10/2014

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D206-642-512 REPAIR

Manufactured No

Each 1.0000

1

D206-642-512 REPAIR

1 x 112860 MF

Skidtube LH, High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float Compatible

D3275-1

Manufactured No

Each 235.0000

12

14-9-9

D3275-1

Crossbolt Spacer

Location

Loc Qty

Loc Code

LG001

235

113246

1

113851

62

114877

74

121868

36

121974

62

D3275-1

Manufactured No

Each 235.0000

12

D3275-1

Crossbolt Spacer

Location

Loc Qty

Loc Code

LG001

235

113246

1

113851

62

114877

74

121868

36

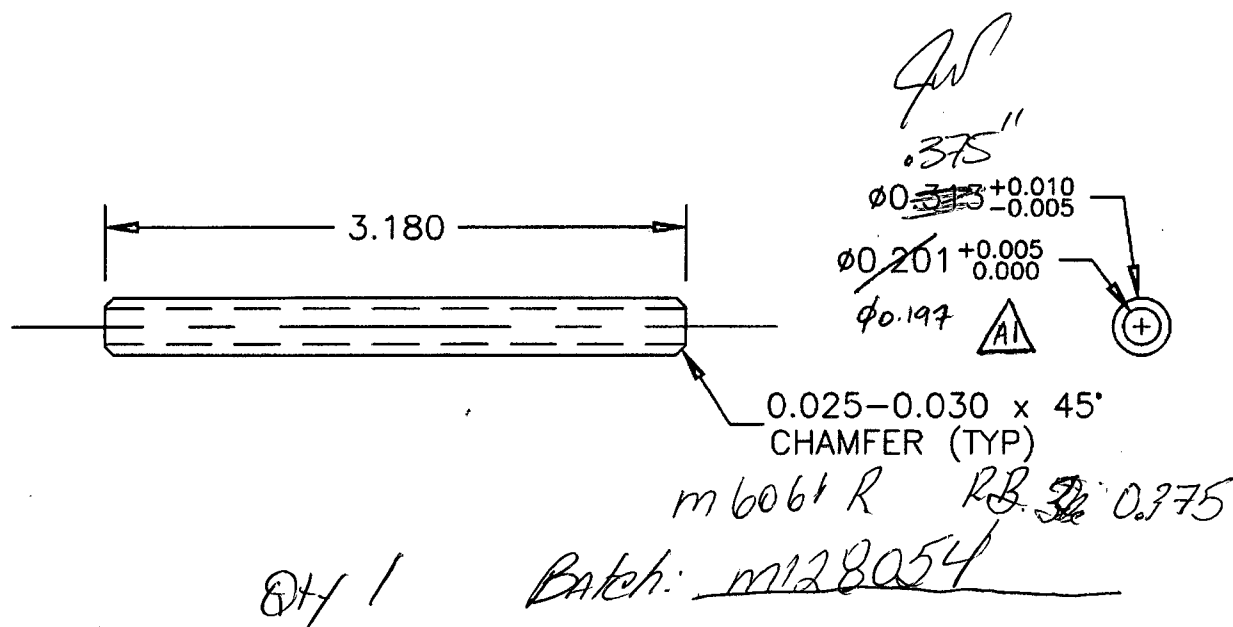
121974

62




DESIGN <i>up</i>	DRAWN BY <i>up</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3275	REV. A SHEET 1 OF 1
DATE 04.03.10		TITLE CROSS BOLT SPACER	SCALE 1:1
A	04.03.10	NEW ISSUE.	
A1	<i>up</i> 04.10.19	CHANGE MAT'L SPEC.	

RELEASED
04.06.22



D3275-1 CROSS BOLT SPACER

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8)
(REF DART SPEC. ~~M6061T6P~~) M6061T6T0.313W.058 
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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RA 111862

Received @ Dart August 2nd, 2014
Inspected@ Dart August 4th, 2014

CUSTOMER: BELL HELICOPTERSTEXTRON INC
CUSTOMER CONTACT: JASON JENKINS
SHIPPED FROM: PINEY FLATS, TN USA

Instructions for RA 111862

- **D206-642-511 B112854 CHG 005**
 - Preform reworking as per RS1020
 - Tube to stay at CHG005
- **D206-642-512 B112860 CHG 005**
 - Preform reworking as per RS1021
 - Tube to stay at CHG005
- No saddles returned with tube
- All original hard ware will be re assembled as per IIN

Time Estimate = 4 DAYS

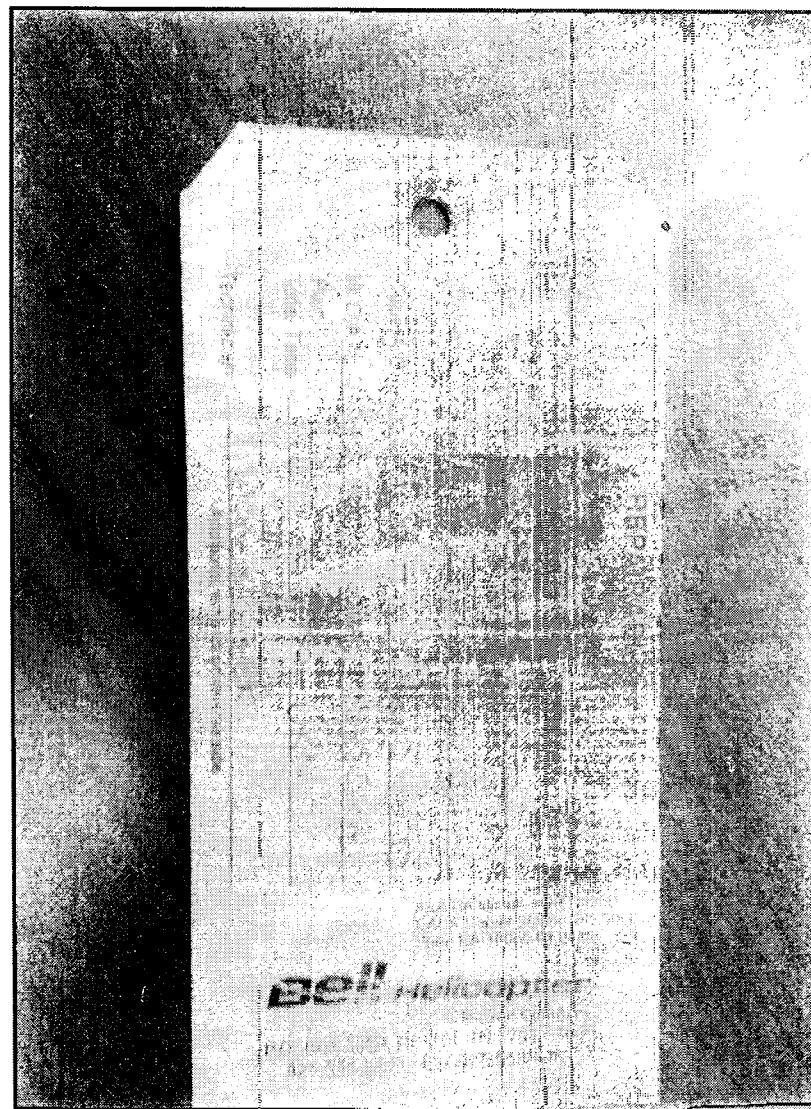
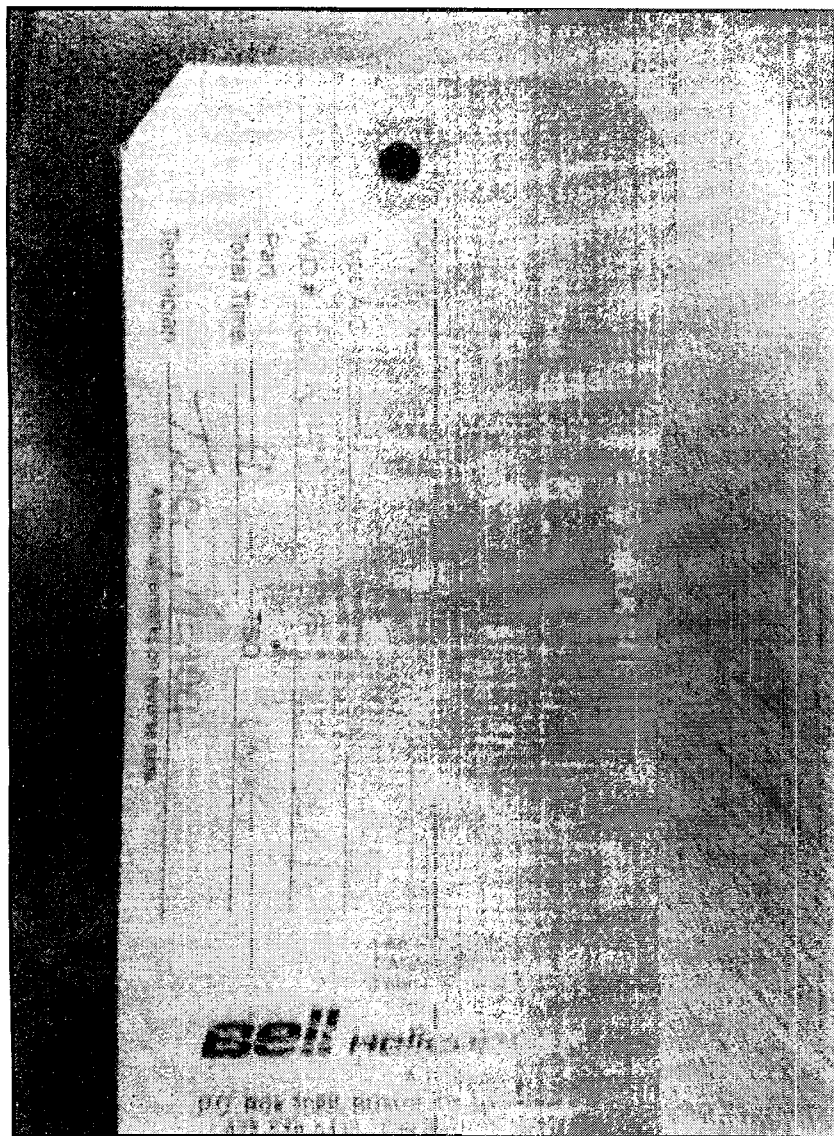
Departments Required: finishing, landing gear (skid tubes), packaging & QC

Pictures Attached = NO

Current CHG # 006 but tube will stay @ CHG005

QTY INSPECTED = x1 D206-642-511 B112854 CHG005
x1 D206-642-512 B112860 CHG005

**THIS INSTRUCTION SHEET MUST
BE ATTACHED TO THE
RESTOCKING WORK ORDER AT
ALL TIMES!!!!**



DART AEROSPACE LTD	Work Order:	
Description: RA 111862 D206-642-512		
Drawing: D3274-041	Repair Scheme:	RS1021
Part No: D206-642-541	Page:	2 of 2
Batch No: B112860	Qty:	1

10	FINISHING	Paint white as per dwg & QSI005 4.2 Paint B 129977 & Exp 2015	DAS 41 9-89	14-9-11	1/11
11	QC	Inspect QC14	DAS 15 9-89	14/09/12	1/1
12	FINISHING	Re assemble all original D parts with all new hard ware <ul style="list-style-type: none"> • AN4C5A BOLT M 127410 x1 • AN960C416 WASHER M 127306 x1 • AN3C4A BOLTS M 129520 x80 • AN960C10L WASHER M 127410 x80 • NAS1515H3L WASHER M 128976 x2 • AN3C37 A BOLT M _____ x4 • D2652 BUSHINGS B _____ x8 • MS21043-3 NUTS M _____ x4 • NAS1149C0332R WASHERS M _____ x4 • D3456-1 WASHER B _____ x1 • D3457-1 WASHER B _____ x2 • MS21043-4 NUT B _____ x1 SIKAFLEX B# M129813 EXP 14/11		14/09/12	1/1
13	QC	Inspect QC 5 Final assembly Ensure that all bolts are at correct torque Ensure that all foreign objects have been removed from inside the skid tube	DAS 38 9-89	14-9-15	
14	STORES / SHIPPING	Identify & Stock			
15	QC	QC21			

Rev	Date	Change Description	Prepared	Checked	Approved
A	13.11.26	New Issue	ED		UP

U:\Admin\Forms\RepairschembIA.doc

Rev. A

Part No: Batch no:

D3537-1 B120645

D3537-3 B115122

D3535-15 B113123

D3536-15 B113613

D3535-23 B114930

D3536-23 B114897

D3535-39 B110704

D3536-39 B113118

D3535-35 B115080

Quantity:

x9

x1

x1

x1

x1

x1

x1

x1

x1

x1

1070 =>

D3536-35

B115087

Y1

~~D3443-1~~

~~B120248~~

~~Y1~~

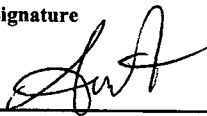
D2646

B119656

Y1

DART AEROSPACE LTD	Work Order:	118450
Description: RA 111862 D206-642-512		
Drawing: D3274-041	Repair Scheme:	RS1021
Part No: D206-642-541	Page:	1 of 2
Batch No: B112860	Qty:	1

Step	Location	Procedure	By	Date	Qty
1	QC	INSPECT RA 111825 D206-642-512 B112860 <ul style="list-style-type: none"> Removed of A/C 407GX S/N54455 Original removal tag attached to work order No saddles returned with skid tubes 			
2	FINISHING / LANDING GEAR (SKID TUBES)	DISASSEMBLE TUBE & ID WITH ORGINIAL BATCH #'S AND D206-642-512 B112860 <ul style="list-style-type: none"> Remove D parts D3407-043 B107368 or B106890 D3413-1 B107984 D2646 B110816 D3414-041 B103607 D3537-1 B114585 D3537-3 B113789 D3535-15 B110746 D3536-15 B113051 D3535-23 B110677 D3536-23 B113010 D3535-39 B107969 D3536-39 B113118 D3535-35 B113151 D3536-35 B113111 Discard all orginial hard ware and to be replaced with new. TAKE SPECIAL CARE NOT TO DAMAGE THE GASKETS			
3	FINISHING	Strip entire tube of all paint & primer as per QSI005			
4	LANDING GEAR (SKID TUBES)	Drill out and remove all x-bolt spacers 8TH, 11TH, 12TH D2649 & D3257-1 Ensure that all foreign objects have been removed from inside the skid tube	BE	140909	1
5	LANDING GEAR (SKID TUBES)	Buff area around x-bolt spacers to be free of any alodine to avoid contamination Weld as per dwg & QSI004 new x-bolt spacers D2649 B _____ qty x _____ D3257-1 B <u>121868</u> qty x <u>2</u> + 1 custom spacer AR <u>M125127</u> SEE ATTACHED FOR FIFTH HOLE.	BE	140909	1
6	LANDING GEAR (SKID TUBES)	A. Buff welds B. Counter bore ϕ .375" holes as per dwg ϕ .313"x0.75" DEEP C. Debur	DD	14-9-9	1
7	QC	Inspect QC 5 + QCU Ensure that SADDLES and GHW fit	S	14/09/10	
8	FINISHING	Re alodine as per QSI005	76	14-9-10	1
9	FINISHING	Prime as per dwg & QSI005 4.2 Primer PRC Desoto 515x349 B <u>129568</u> & Exp <u>2015</u>	DAS 41 9-89	14-9-11	1

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE Form One			3. Form Tracking Number: PS-2014-09-16-1	
4. Organizations Name and Address: Dart Aerospace Ltd., 1270 Aberdeen Street, Hawkesbury, Ontario, K6A 1K7, CANADA Tel: 1 (613) 632-5200 Fax: 1 (613) 632-5246 www.dartaero.com					5. Work Order/Contract/Invoice PO145700EA	
6. Item:	7. Description:	8. Part Number:	9. Quantity:	10. Serial/Batch Number:	11. Status/Work:	
1	Float Skid Tube	D206-642-512	1	B118450	Repaired	
12. Remarks: Part returned from customer for repair according to Dart Engineering repair Scheme RS1021 carried out on work order B118450. Part was removed from Bell Registration Aircraft 407GX at 9.0 hour on work order C21045EA. Original part Batch # B118450. Returned to Dart on Return Authorization Form RA#111862.						
13a. Certifies that the items identified above were manufactured in conformity to: <input type="checkbox"/> Approved design data and are in a condition for safe operation. <input type="checkbox"/> Non-approved design data specified in Block 12.			14a. <input checked="" type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulations specified in Block 12 Certifies that unless otherwise specified in Block 12, the work identified in Block 11 and described in Block 12, has been performed in compliance with the <i>Canadian Aviation Regulations</i> .			
13b. Signature		13c. Approval Organization Number		14b. Signature  DAS 29 9-89		14c. Approved Organization Number 9-89
13d. Name		13e. Date (dd/mm/yyyy):		14d. Name Patrick Smith		14e. Date (dd/mm/yyyy): 16/Sep/2014
30 Dec 2008(Previously form 24-0078)						
<p align="center">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than the authority specified in Block 1, must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements 13a or 14a do not constitute installation certification. In all cases, the aircraft technical record must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						

EXTRUSION INSPECTION SHEET



		SIDE A		SIDE B		Measurement unit		Inches		Symbol		ULTRA SONIC MEASUREMENTS			
TUBE #	TOTAL LENGTH	DIA		DIA		INSIDE DIA	wall thickness measured w/vern		Strightness at 12" in middle	Rockwell Reading	LOCATION on tube	R1	R2	R3	R4
		R1	R2	R1	R2										
DWG							A	B		N/A	Middle	N/A			
1	129.8	3.493	3.496	3.496	3.498	2.223	.644	.628	.0135	N/A	Middle	.613	.625	.656	.644
2	"	3.496	3.502	3.499	3.508	2.224	.628	.643	.0062	N/A	Middle	.634	.646	.636	.623
3	"	3.495	3.495	3.496	3.488	2.223	.622	.622	.0056	N/A	Middle	.623	.629	.644	.636
4	"	3.500	3.500	3.495	3.500	2.223	.645	.645	.0031	N/A	Middle	.657	.641	.645	.632
5	"	3.492	3.492	3.499	3.488	2.224	.630	.629	.0011	N/A	Middle	.621	.624	.639	.636
6	"	3.499	3.499	3.484	3.504	2.222	.631	.636	.0044	N/A	Middle	.642	.650	.625	.627
7	"	3.497	3.497	3.502	3.507	2.226	.634	.622	.0026	N/A	Middle	.626	.624	.635	.642
8	"	3.500	3.501	3.499	3.489	2.226	.623	.648	.0036	N/A	Middle	.645	.639	.619	.621
9	"	3.496	3.502	3.502	3.504	2.226	.620	.634	.0044	N/A	Middle	.642	.624	.632	.640
10	"	3.508	3.504	3.504	5.50	2.225	.621	.630	.0054	N/A	Middle	.649	.615	.625	.652
11										N/A	Middle				
12										N/A	Middle				
13										N/A	Middle				
14										N/A	Middle				
15										N/A	Middle				
16										N/A	Middle				
PART #		P/O#				BATCH #				Notes:					

REPAIRABLE

Part Name F/OAT SKID/LOBE RH

Part # D206-642-502 S/N B112560

Owner BHT Date 8-6-14

Type A/C 407GX TT 9.0 S/N 54455

W.O.# C21045EA DMR C21045EA/S

Part
Total Time (1) TSO LOK

Technician TRACY MEADOR

Additional remarks on reverse side.

FAA Certificate #FKFR930D
EASA Repair Station 145.5066
Form EA-10060-01 04/08

BE! Helicopter

A Textron Company
P.O. Box 3689, Bristol, TN 37625-3689
423-538-5111 Fax 423-538-8469

Discrepancy: Holes Drilled Improperly THROUGH

SKID TUBE